

# Work Order ID 73278

Tuesday, August 30, 2011 12:01:11 PM



Page 1

Item ID: D3340-19

Accept



Setup Start



Revision ID:

Stop



Item Name: Center Skidtube Protector

Start Date: 8/29/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Draw Nbr

Revision Nbr

D3340

Rev B

100



Waterjet

Memo

Set Up/  
Run Hours

0.00

BB11-9-20

FLOW CNC Waterjet

1010 .40

Cut as per dwg.

Prog. rev: B

dwg rev: B

110



QC2- Inspect parts off machine FAI/FAIB

0.00

BB11-9-20

QC

Memo

0.00

Quality Control

Ensure material release note is attached

120



QC8- Inspect parts - second check

0.00

0.00

8/10/21

47

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130

Operation  
Description

NC BRAKE

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Brake NC

Brake NC

Memo

0.00

8/30/22

④

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

8/30/22

④

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Powder Coating

Memo

12:45 0.00

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

325° F

175

4X Ø m-f 14/09/22

W117338

W/O:		WORK ORDER CHANGES					
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**Work Order ID 73278**

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Page 3

Item ID: D3340-19

Accept



Setup

Start



Revision ID:

Item Name: Center Skidtube Protector

Stop



Start Date: 8/29/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



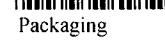
QC

Quality Control

4

BR 11-09-22

170

Identify as per dwg & Stock Location SP 500 0.00

Packaging

Packaging

Memo

0.00

SP 11-09-22

180

QC21- Final Inspection - Work Order Release 0.00



QC

Quality Control

Memo

0.00

11/9/27/08

MF 11-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

# Picklist Print

Tuesday, August 30, 2011 12:01:09 PM

Page 1

Work Order ID: 73278



Parent Item: D3340-19



Parent Item Name: Center Skidtube Protector

Start Date: 8/29/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A 05.11.10 Preliminary issue AP/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3340-19F 		Purchased	No			100	Each	0.0000	1	4	4	8/31-9-20	

Wearplate

1010 .40

M 116 791

(4)

8/30/2011

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 73278

Description: CENTER SLIDETUBE PROTECTOR

Part Number: D3340-19

Inspection Dwg: D334019, Rev: B

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

First Article       Prototype

Measured by: **IR**

Audited by:

**Prototype Approval:**

Date: 11-9-20

Date: 11/09/21

Date:

Rev Date Change

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—  
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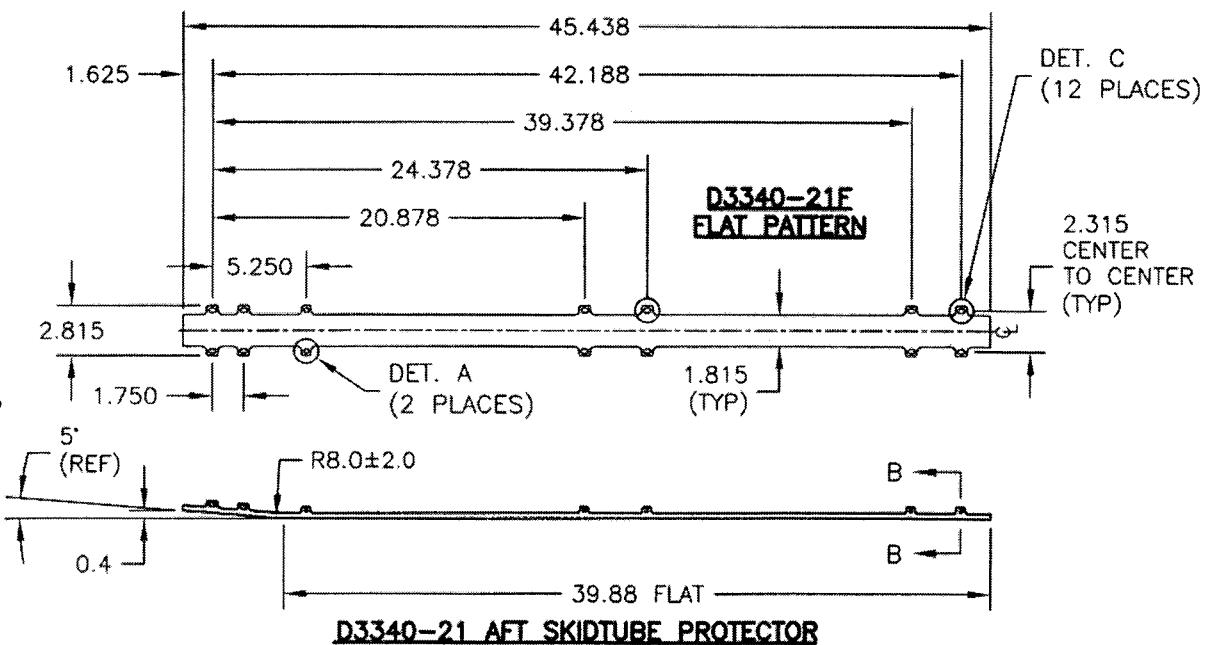
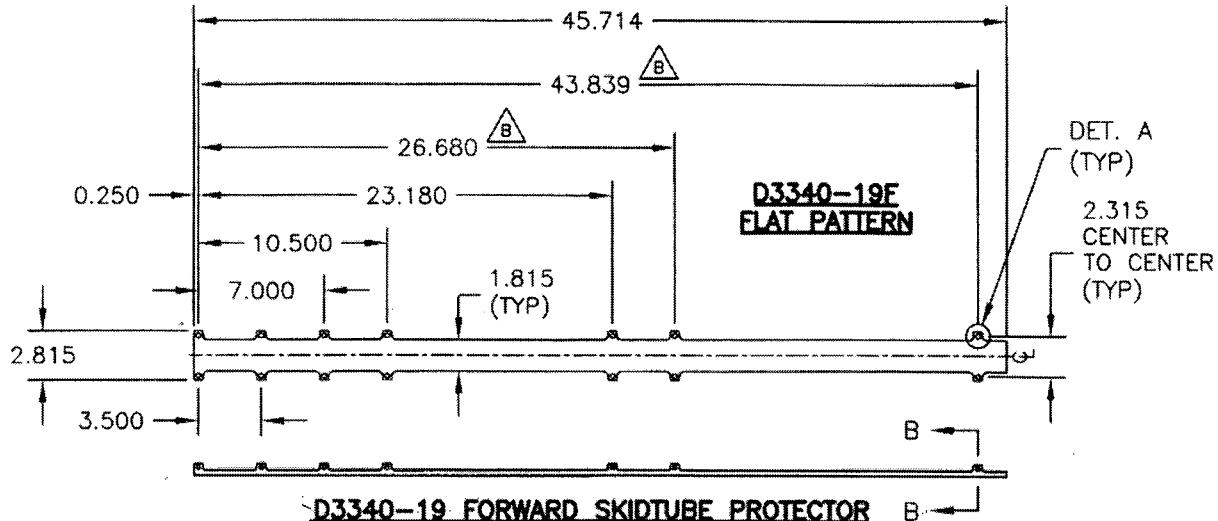
Revised by      Approved

Rev Date Change  
A New issue

KJ/JLM



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3340	REV. B SHEET 8 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

RELEASED  
05.11.28  
*#*

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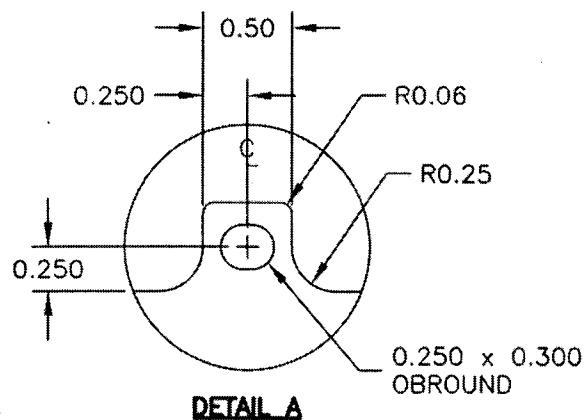
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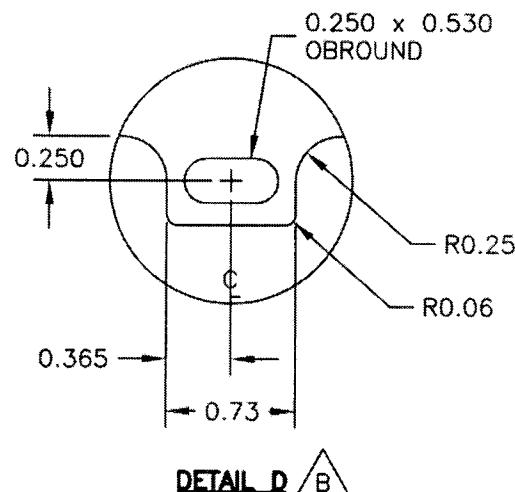
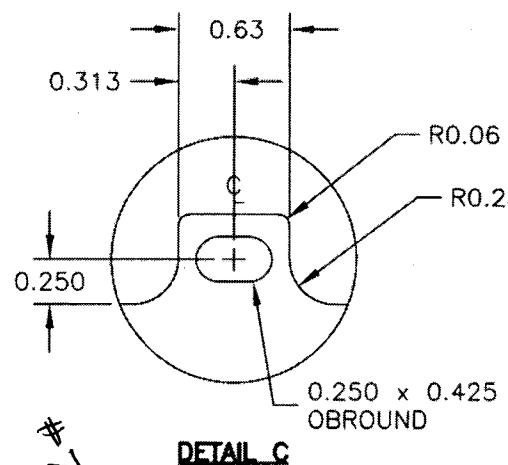
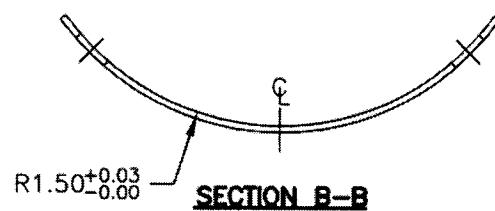
NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3340
DATE 05.11.22	TITLE	REV. B SHEET 11 OF 11 SKIDTUBE PROTECTOR 1:1



RELEASED  
05-11-28



W/O:		WORK ORDER CHANGES					
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